

Fig 5

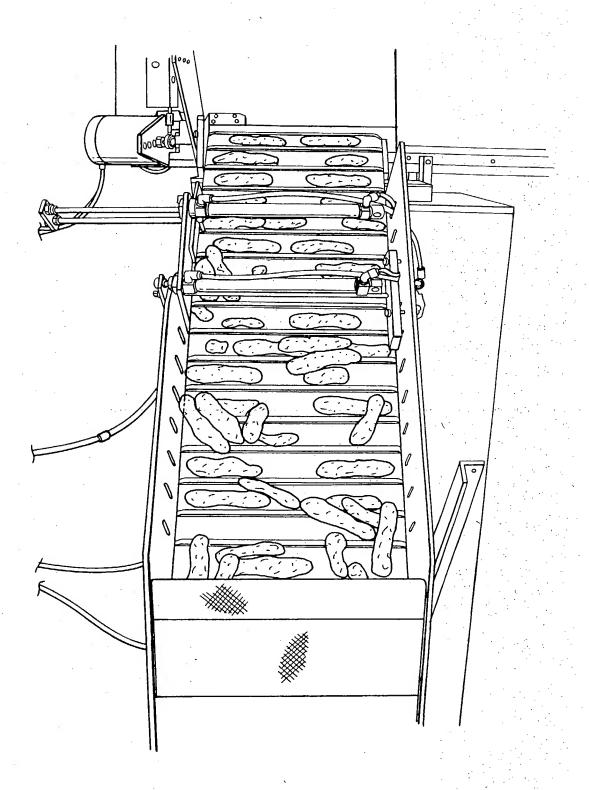


Fig. 6

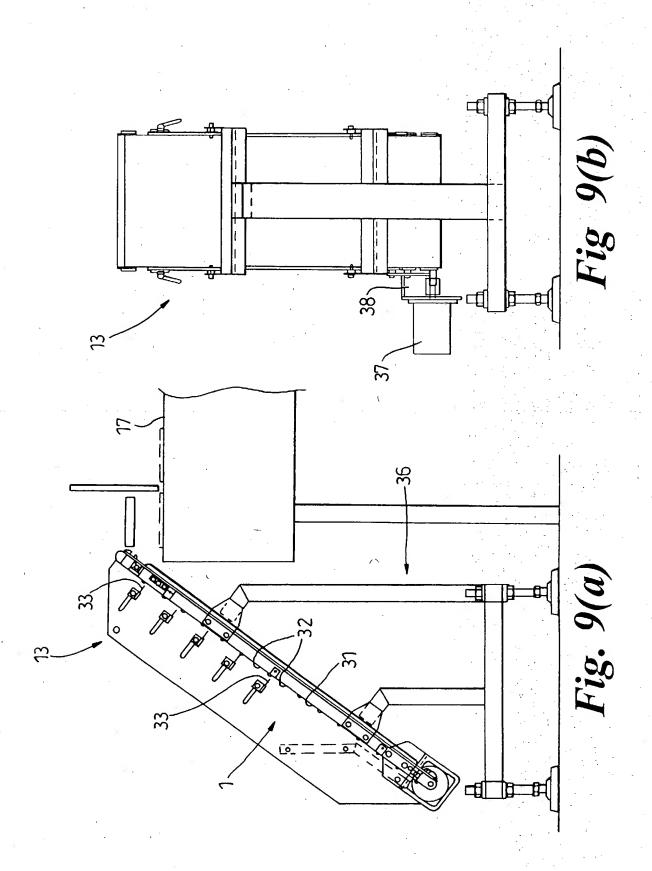
Conveyor sequencing 6 slice start 5 slice singulating

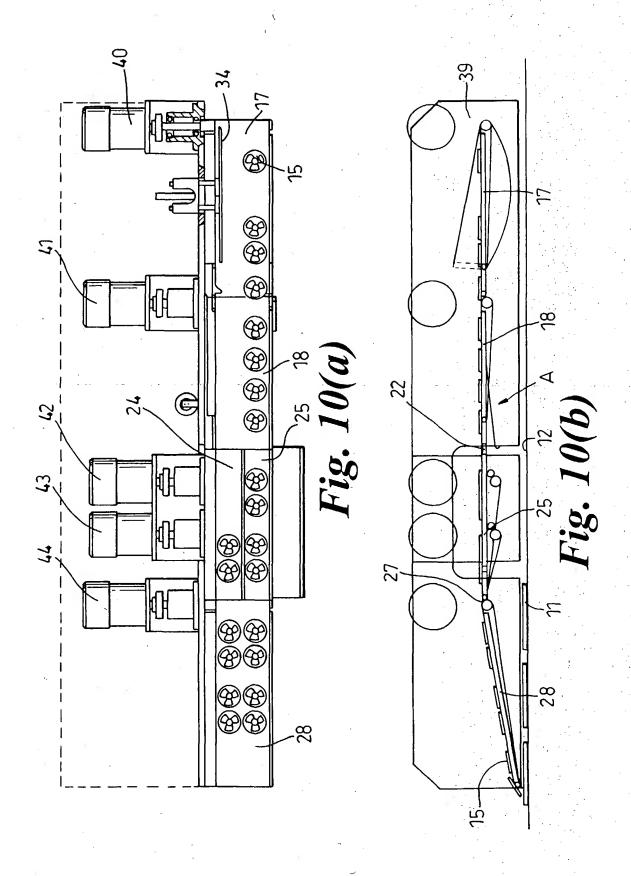
Acia 6	Six slices available at start, Singulator output 5 good slices Start point is immediately after slice deposit on last bread slice	good slices		
0 0 0000 0000 0 0 0 0 0 0 0 0 0 0 0 0	Shiting slices from axis 1 to 2 (60mm increments) Slice moves time	Bread sive cycle time Time to next deposit start 6 sive HSpeed transfer time (axes 3-4)	2000 it. 2.00 ingredient slices per sec 1000 531	
Start	1 241	8 slice HSpeed transfer time axis 6 Axis 2 to 3 (or 2 to 4) slice transfer time	770 276 s1=13 b1=40 01=17 (2=10	
event 10 Axis 5 (signshift)	3 417	Axis 5 ideshift time		
1063 Aris 9 Aris 4	4 462	Singualate time	1050	
0000 000000 Acrs 1			,	
00000	Event	axis 2 axis 3 axis 4 axis 5 axis 6 Sing	Singulator	
0 0 0 0 0 0 Singulation	Axes 34 Migh speed transfer 8 sines	531 531 531 531 320 531 531 531 531 531 531 531 531 531 531		
Start	Peposit 4 slices		South Desiration of the second	
event 19 Axis 5 (sideshift)	S Ide Asies	1000		
	Transfer 1-2-3	276 276 276		
00 0000 00000 Axis 1	making and idle	276 278 278 278 278	276 aus 5	
	Idle	7/0	276	
20000 0000	Sideshiff are 5	232	204 4 East	
	12	235		
even 21 Axis 5 (sideshift)	Transfer 2-4 13	276 276 376 376	The state of the s	
	sfer 2-4 15	276 276		
00000 00000 0000 Axis 1	idle 16 7	276 276 276 276 276	Z Store	
	18	276		
orehone 0 0 0 0 0	Transfer 2-1 19 2	76 276 276 276		
	shift auds 5. The second second		0 500 1000 1500 2000 2500 3000 3500 4000	3500 4000
evert 26 Axis 5 (sideshift) 2904 Axis 6 Axis 4	idle 22 Errory Boss 1 (4 stos move) 23 23	235 235		
0000		247 247 247	771	
Axis 2 00000	9.8	276 276 276		
	27	,		
0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	Transfer 1-2-3	276 276 .276 .276 .276		
	Idle waiting for axis 6 to clear 30	١.	46	
Beginning Axis 5 (sidestrift) next cycle Axis 6 Axis 4	Total placement cycle time	4000		
0000 00000 0000				
Auis 2 00000				
0 0 0 0 0 0 0 O O O			/ DIH	

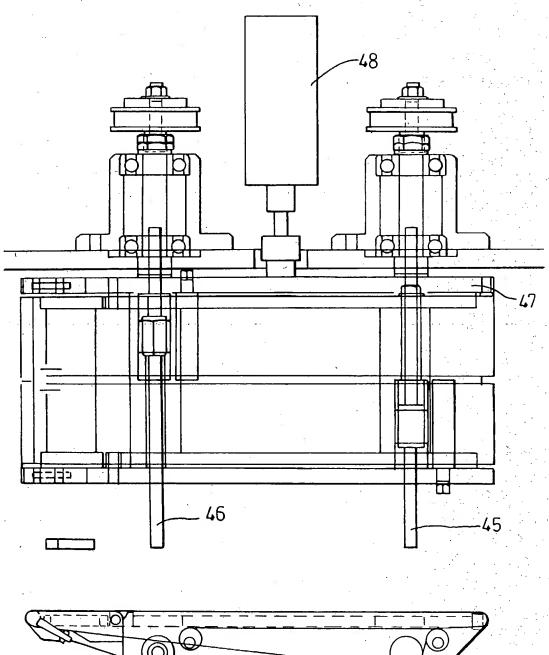
of relacions	 -	114342

					·				4. 5	l.
	Bell/conveyor		Angle to		Scraper to belt	Acceleration	Height from top of singulator belt to axis 1		Input end roller	Discharge er
Module	detall	Slat detail	horizontal	Scraper detail	distance mm	mm/sec/sec.	surface	Hopper	DIA	roller DIA
Singulator				-						
conveyor	<del> </del>			20mm deep	,					· · · ·
				continuous strip					. "-	
	300mmx2280m mx1.2mm,habasi	4.0mm Hx 8mm		polypropylana sheet 0.015in				RIMEX vertical	·	
Cucumber	it FNB-5E	W, 60mm pitch	52.5deg	thick	6,5,5,5,5	14500	10mm	rear wall	: Any	24mm
	<del> </del>			э вспирета,						<del></del>
	300mmx2280m			20mm deep continious strip	•					
Tomato	mx1.2mm habasiit FNB-5E	4.0mm Hx 6mm W, 60mm pitch	52.5deg	polypropylene sheet 0.015in	8,7,7.7,7	14500	10mm	RIMEX vertical rear wall	Any	24mm
	7-50231X : 110 GE	TT, CONTAIN JACON	02.000		0,1,1,1	14000	TOTAL	1001 #101		
	300mmx2280m			no scrapers, 2 air operated						
•	mx1.2mm	4.5mm Hx 6mm	5054	deflectors stroke		44000		RIMEX vertical		123.4
Sausage	habasia FNB-5E	W, 45.6mm pitch	52.5deg	200mm		11300	10mm	rear wall	Any	24mm
									; ,	
				1			Height from top of singulator		18.5	
	Belt/conveyor		Angle to		Scraper to belt	Acceleration	belt to axis 1		input end roller	Discharge e
Module	detail	Slat detail	horizontal	Scraper detail	distance mm	mm/sec/sec.	surface	Hopper	DIA	roller DIA
	120mm widex350mm						1	٠.	·	
	longx 0.8mm						1		-	
AXIS 1	Habasii FAB- 5ER	N/A	Horizontal	N/A	N/A	4100			any	8.0mm
70110				10/1						
	1			Pusher blade to						
Pusher	N/A			align slices prior to grabbing	1-2mm	4100	N/A		N/A	N/A
	120mm									
	widex350mm									
	longx0.8mm Habasit FAB-			l '						
AXIS 2	5ER	N/A	Horizontal	ļ	N/A	4100	N/A		20mm	8.0mm
	ļ			<del></del>						
								*.		
				l .			Height from top of singulator	,	4 7	
	Belt/conveyor		Angle to		Scraper to belt	Acceleration	belt to axis 1		input and roller	
Module	detail 60mm	Stat detail	horizontal	Scraper detail	distance mm	mm/sec/sec.	surface	Hopper	DIA	roller DIA
	widex250mm								And the same	
	longx0.8mm Habasit FAB-	•						11.		
AXIS 3	5ER	N/A	Horizontal	N/A	N/A	4100	N/A		20mm	8.0mm
	60mm			<del></del>		····	<del> </del>	ļ <u>.</u>		
	widex250mm							5	1.0	
	longx0.8mm Habasil FAB-			i			i			
AXIS 4	5ER	N/A	Horizontal	N/A	N/A	4100	N/A		20mm	B.Omm
		-		<del> </del>						
	Linear unit			1						
AXIS 5	moving Axis3 and 4 ,120mm stroke	. N/A	Horizontal	N/A	N/A	4100	N/A ·		N/A	NVA
~~13 3	- ,120mm1300KB		I IOI ZOI KZ	N/A	.VA	- 100				
	120mm									
	widex295mm longx0.8mm			!					*	
AXIS 6	Habasit FAB- 5ER	N/A	7.5	N/A	N/A	4000Accn 2000Dccn	N/A	}	20mm	B.Omm
AXIS 6	DEN .	N/A	7.5	N/A	N/A	ZUUUDECH	N/A		ZORINII .	B.Urim
									. :	
	DT/Heachi KP-3 Camera 600mm							٠٠.		, i.e.,
Camera	above conveyor	N/A						*,		1 1
Other	Facility for								1.	100

Fig 8







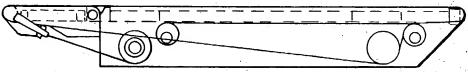


Fig 11

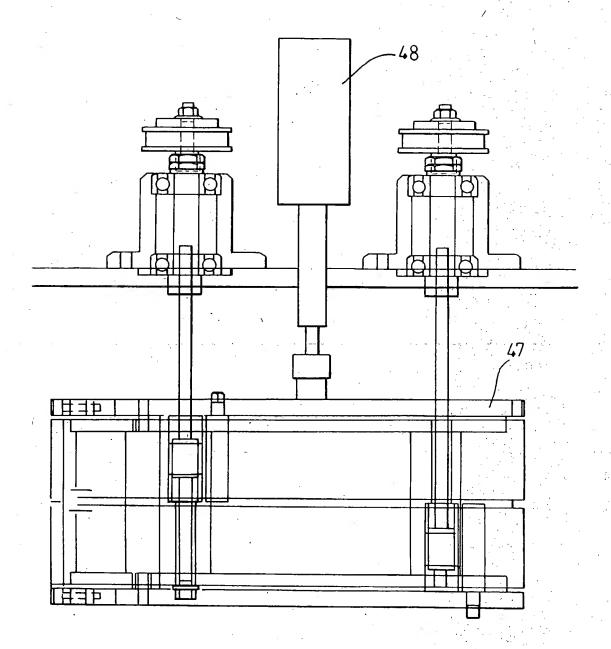


Fig. 12